

Date: Thursday, 2/23/2006 10:24:32 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 25931		
Estimate Number	: 10514		
P.O. Number	: N/A	Part Number	: D28051
This Issue	: 2/23/2006 S.O. No. : N/A	Drawing Number	: D2805 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 3/22/2006
Checked & Approved By	: <u>JG 06.02.23</u>	Qty:	30
Comment	: Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC	Um:	Each
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"	
Comment:	Qty.: 0.2756 f(s)/Unit Total : 8.2688 f(s) 6061-T6 Bar 1.5" x 1.5"		(1)
	Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" (M6061T6B1500X01500)	Batch: M16954	mk 06/03/01 30
2.0	BAND SAW	BAND SAW	
Comment:	BAND SAW Cut Bar: 3.150" Long +0.010/-0.030"		mk 06/03/01 31
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment:	HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr Identify as D2805-1		mk 06/03/01 31
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		mk 06/03/01 31
5.0	QC8	SECOND CHECK	
Comment:	SECOND CHECK	M8	06/03/06 31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/01	3	1 piece scrap. the drill broke inside the piece 1 piece scrap the piece was outside	AB QHILD	destroy and replace	ML 06/03/01 AB-03-01	/	AB QHILD	Z 06/03/01

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:33 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 25931

Part Number: D28051

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5A0

06/03/06

31

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 386

6/3/06 (3)

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

6/3/06 (3) !

Job Completion



6/03/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25931
Description: Stop	Part Number:	D2805-1
Inspection Dwg: D2805 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

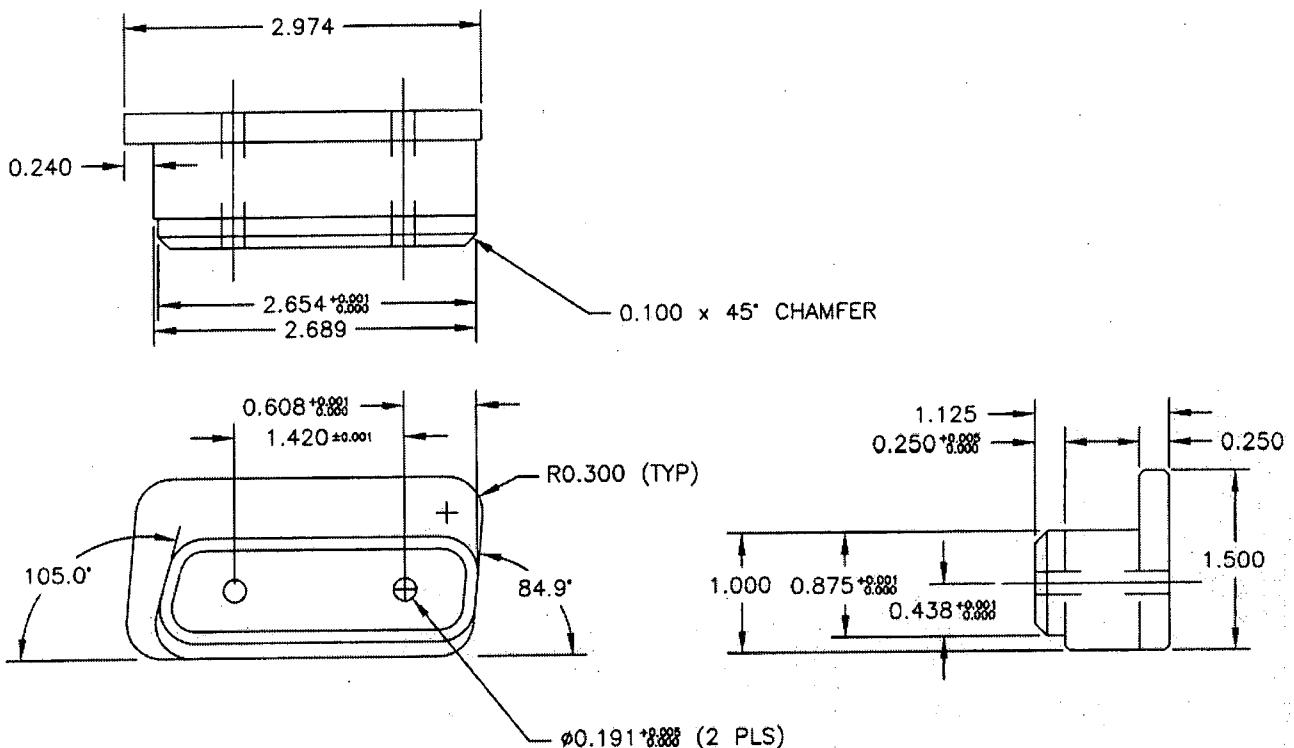
X First Article Prototype

Measured by:	<u>MJ</u>	Audited by:	<u>EP</u>	Prototype Approval:	N/A
Date:	06/03/01	Date:	06/03/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	

DARTISSUED
COPY

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2805 REV. B SHEET 1 OF 2
DATE		TITLE SCALE
01.03.13		STOP 2:3
A	00.10.31	NEW ISSUE
B	01.03.13	ADD -3/-4

RELEASED
01.03.16

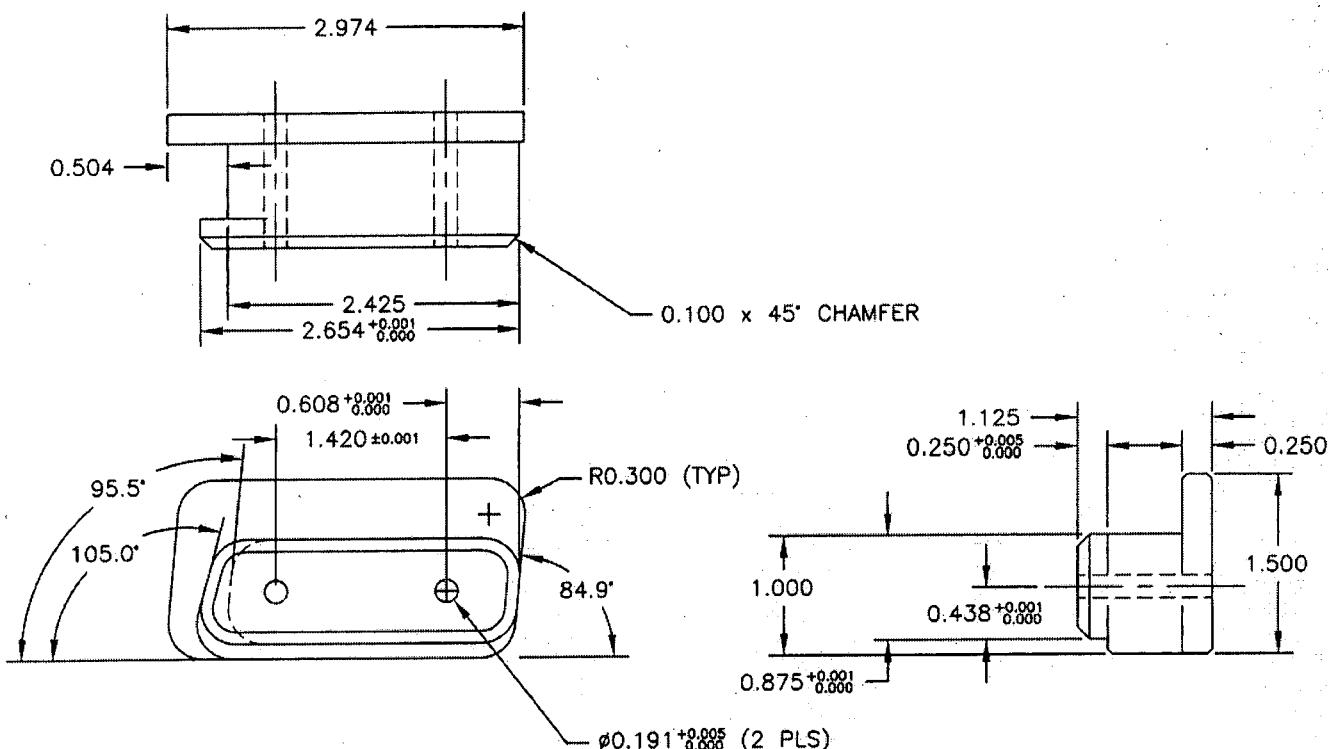
D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED
 BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED
 MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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 WITHOUT NOTICE
 WORK ORDER
 NO. 25931

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2805
DATE		TITLE STOP

REV. B
SHEET 2 OF 2SCALE
2:3**RELEASED**
01.03.16D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED
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